

Date: Thursday, 12/06/2008 3:46:54 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: LATCH BRACKET
<b>Job Number</b>	: 39849		
<b>Estimate Number</b>	: 10994		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D2583
<b>This Issue</b>	: 12/06/2008	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D2583 REV. B
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 38032	<b>Drawing Revision</b>	: B
	<b>Type</b> : SMALL / MED FAB	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 30/06/2008
		<b>Qty:</b>	20 Um: Each
<b>Checked &amp; Approved By</b>	: <u>Julie Lecocq</u>		
<b>Comment</b>	: Est: C 00.11.01 Removed P/O for Powder Coat- in house processDM		
	Est: D 06.07.21 Waterjet EC		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M5052H32S040	5052-H32 .040 Sheet
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**Comment:** Qty.: 0.1227 sf(s)/Unit Total : 2.4549 sf(s)

Material: 5052-H32 (QQ-A-250/8) 0.040" thick  
 (M5052H32S040)

Batch: 106 900 IB 8-6-16

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D2583

Dwg Rev: B  
 Prog Rev: B

IB 8-6-16



2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 8-6-16

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

S 08/06/19 (32) counter

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

Deburr

Form on CNC Brake as per Dwg D2583

D 08/06/16 (32)

SB 08/06/19



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/06/2008 3:46:54 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LATCH BRACKET

Job Number: 39849

Part Number: D2583

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*center*  
*S 08/06/12 (x32)*

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*M- 08/06/19*

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

*10:35*

OVEN TEMPERATURE:

*320°*

FINISH TIME:

*11:05*

*FL 08/06/23*

*(32)*

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*M- 08/06/24*

*(32x)*

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*ST 222*

*SS 08/06/25 (x32)*

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/06/25*

Job Completion



*MF 08-06-25*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

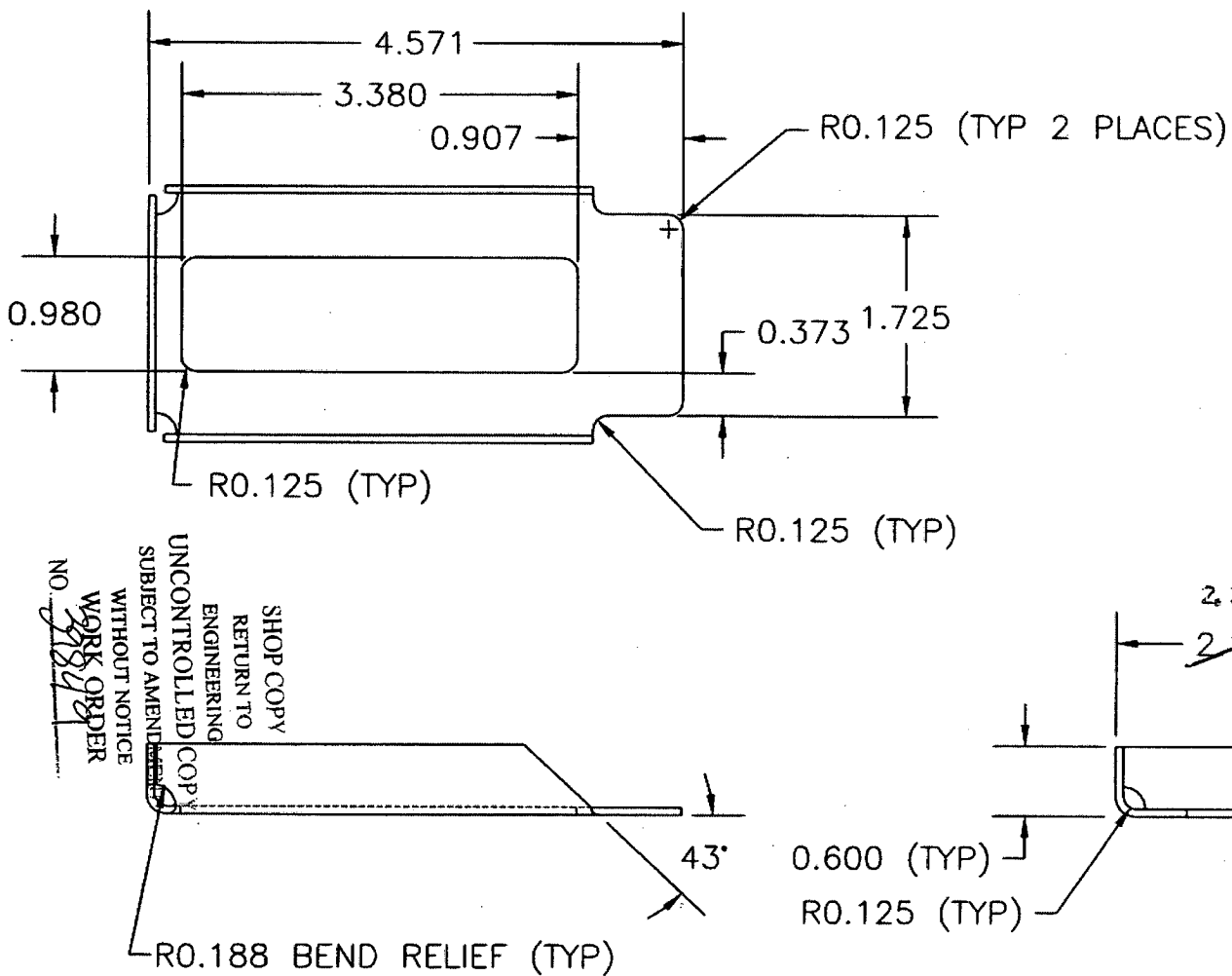
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**DART****RELEASED**  
KE 99.02.25

DESIGN	MIKE M.	DRAWN BY	RF	DART AEROSPACE LTD
CHECKED	CP	APPROVED	KE	HAWKESBURY, ONTARIO, CANADA
DATE	99.02.22	DRAWING NO.	D2583	REV. B
		TITLE	LATCH BRACKET	SHEET 1 OF 1
				SCALE
A	96.07.10	NEW ISSUE		2:3
B	99.02.22	CHANGE OF FINISH (PER TSR A887)		



MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
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WORK ORDER  
NO. 2884